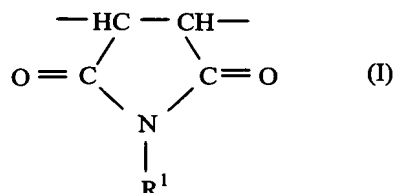


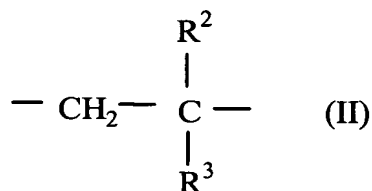
## CLAIMS

1. A stretched film (X) obtained from a resin composition by melt-extrusion casting followed by stretching at least in one direction,

- 5 (1) the resin composition containing a maleimide-olefin copolymer (A) having 40 to 60 mol% of a recurring unit represented by the following formula (I),



- 10 wherein  $\text{R}^1$  is a hydrogen atom, an alkyl group having 1 to 6 carbon atoms or a monovalent aromatic hydrocarbon group, and 60 to 40 mol% of a recurring unit represented by the following formula (II),



- 15 wherein each of  $\text{R}^2$  and  $\text{R}^3$  is independently a hydrogen atom or an alkyl group having 1 to 6 carbon atoms,

and an acrylonitrile-styrene copolymer (B) containing 21 to 45 % by weight of an acrylonitrile unit,

- 20 the resin composition having a copolymer (A) content of at least 50 % by weight but not more than 99 % by weight and a copolymer (B) content of at least 1 % by weight but not more than 50 % by weight,

- (2) the stretched film (X) having a maximum retardation ( $\text{R}_p$ ) at 550 nm in an in-plane direction, the maximum retardation satisfying the following expression,

$$10 \text{ nm} < \text{R}_p \leq 400 \text{ nm}$$

- (3) the stretched film (X) having a retardation

(Rth) at 550 nm in the thickness direction, the retardation satisfying the following expression,

$$0 \text{ nm} < |R_{th}| \leq 400 \text{ nm}.$$

5    2.        The stretched film of claim 1, wherein

(1-a) the resin composition has a copolymer (A) content of over 75 % by weight but not more than 99 % by weight and a copolymer (B) content of at least 1 % by weight but less than 25 % by weight,

10        (2-a)  $R_p$  satisfies the following expression,

$$10 \text{ nm} < R_p \leq 250 \text{ nm}$$

and

(3-a)  $R_{th}$  satisfies the following expression,

$$0 \text{ nm} < |R_{th}| \leq 400 \text{ nm}.$$

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3.        The stretched film of claim 1, wherein

(1-b) the resin composition has a copolymer (A) content of over 50 % by weight but not more than 65 % by weight and a copolymer (B) content of at least 35 % by weight but less than 50 % by weight,

20        (2-b)  $R_p$  satisfies the following expression,

$$10 \text{ nm} < R_p \leq 400 \text{ nm}$$

and

(3-b)  $R_{th}$  satisfies the following expression,

25         $0 \text{ nm} < |R_{th}| \leq 400 \text{ nm}.$

4.        The stretched film of claim 3, which satisfies the following expressions,

$$n_y < n_z < n_x \text{ and}$$

30         $0.3 \leq \{ (n_x - n_z) / (n_x - n_y) \} \leq 0.9,$

wherein  $n_x$  is a refractive index in an in-plane lagging axis direction at 550 nm,

$n_y$  is a refractive index in a direction perpendicular to the in-plane lagging axis at 550 nm,

and

$n_z$  is a refractive index in the thickness direction at 550 nm.

- 5     5.     The stretched film of claim 1, which is a product by the stretching at a stretch ratio that satisfies the following expression,

$$R^{MD} > R^{TD} \text{ or } R^{TD} > R^{MD}$$

         wherein  $R^{MD}$  is a stretch ratio in the machine  
10    direction and  $R^{TD}$  is a stretch ratio in the transverse direction.

6.     The stretched film of claim 5, wherein  $|R^{MD}/R^{TD}|$  or  $|R^{TD}/R^{MD}|$  is in the range of over 1.0 but not more than 5.0.

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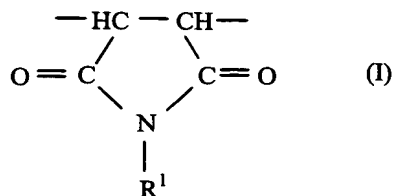
7.     The stretched film of claim 1, which is a biaxially stretched film.

8.     The stretched film of claim 1, which has one or  
20    less coarse streaked projection having a height of 10  $\mu\text{m}$  or more, a width of 0.3 mm or more and a length of 5 cm or more, per meter of width in the transverse direction of the stretched film.

- 25    9.     The stretched film of claim 1, which has a water vapor permeability of 5 to 250  $\text{g}/(\text{m}^2 \cdot \text{day})$ .

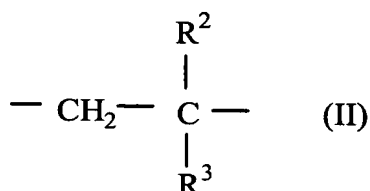
10.    A process for the production of a stretched film, which comprises forming a film from a resin composition  
30    by melt-extrusion casting and then stretching the film at least in one direction,

         (1) the resin composition containing a maleimide-olefin copolymer (A) having 40 to 60 mol% of a recurring unit represented by the following formula (I),



wherein  $\text{R}^1$  is a hydrogen atom, an alkyl group having 1 to 6 carbon atoms or a monovalent aromatic hydrocarbon group,

5 and 60 to 40 mol% of a recurring unit represented by the following formula (II),



wherein each of  $\text{R}^2$  and  $\text{R}^3$  is independently a hydrogen atom or an alkyl group having 1 to 6 carbon atoms,

10 and an acrylonitrile-styrene copolymer (B) containing 21 to 45 % by weight of an acrylonitrile unit,

the resin composition having a copolymer (A) content of at least 50 % by weight but not more than 99 % by weight and a copolymer (B) content of at least 1 % by weight but not more than 50 % by weight,

(2) the film being stretched at a stretch ratio that satisfies the following expression,

$$\text{R}^{\text{MD}} > \text{R}^{\text{TD}} \text{ or } \text{R}^{\text{TD}} > \text{R}^{\text{MD}}$$

20 wherein  $\text{R}^{\text{MD}}$  is a stretch ratio in the machine direction and  $\text{R}^{\text{TD}}$  is a stretch ratio in the transverse direction.

11. The Process of claim 10, which the stretching is carried out by biaxial stretching.

12. The process of claim 10, wherein  $|\text{R}^{\text{MD}}/\text{R}^{\text{TD}}|$  or  $|\text{R}^{\text{TD}}/\text{R}^{\text{MD}}|$  is in the range of over 1.0 but not more than 5.0.

13. The process of claim 10, wherein  $R^{MD}$  is in the range of 1.0 to 1.8 and  $R^{TD}$  is in the range of 1.5 to 3.5.

5 14. The process of claim 10, wherein the stretching is carried out at a stretching temperature ( $T_d$ ) in the range of  $T_g$  to  $(T_g + 40^\circ C)$  in which  $T_g$  is a glass transition temperature of the resin composition, and at a stretching velocity of 5 to 5,000 %/minute.

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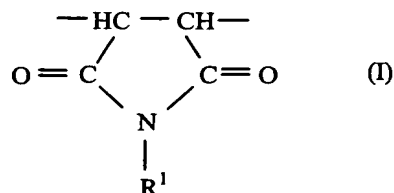
15. A laminated material comprising the stretched film (X) recited in claim 1 and a polarizer formed thereon.

15 16. The laminated material of claim 15, wherein the polarizer is formed from a polyvinyl alcohol containing iodine or an anisotropic dye.

17. The laminated material of claim 15, wherein a  
20 film is further formed on the polarizer.

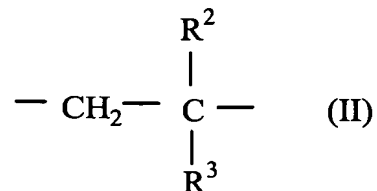
18. The laminated material of claim 15, wherein the film is a stretched film (Y) formed from a resin composition by melt-extrusion casting followed by  
25 stretching at least in one direction,

(1-c) the resin composition containing a maleimide-olefin copolymer (A) having 40 to 60 mol% of a recurring unit represented by the following formula (I),



30 wherein  $R^1$  is a hydrogen atom, an alkyl group having 1 to 6 carbon atoms or a monovalent

aromatic hydrocarbon group,  
and 60 to 40 mol% of a recurring unit represented by the  
following formula (II),



5            wherein each of  $\text{R}^2$  and  $\text{R}^3$  is independently a  
hydrogen atom or an alkyl group having 1 to 6  
carbon atoms,

and an acrylonitrile-styrene copolymer (B) containing 21  
to 45 % by weight of an acrylonitrile unit,

10            the resin composition having a copolymer (A)  
content of over 65 % by weight but less than 75 % by  
weight and a copolymer (B) content of over 25 % by  
weight but less 35 % by weight,

(2-c) the stretched film (Y) having a maximum  
15    retardation ( $\text{R}_p$ ) at 550 nm in an in-plane direction, the  
maximum retardation satisfying the following expression,  
 $\text{R}_p < 10 \text{ nm}$ .

19.        The laminated material of claim 15, which is a  
20    sheet polarizer.

20.        A liquid crystal display comprising a liquid  
crystal cell and laminated materials of claim 15  
arranged on both surfaces of the liquid crystal cell.